



## **Commodity Specification**

# **WHITE TURKEY ROAST**

**August 1997**



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## I. GENERAL

White turkey roasts (roasts) produced from ready-to-cook young turkeys under this Specification will be packaged and packed in the following form as specified in the contract:

White Roasts (233840) - Frozen ready-to-cook white turkey roasts must weigh not less than 8 pounds (3.63 kg) and not more than 12 pounds (5.44 kg). Roasts must be packaged in elasticized netting and moisture-proof casings or plastic-film bags and packed four roasts per fiberboard shipping container. A purchase unit will total 40,000 pounds (18,144 kg).

## II. COMMODITY SPECIFICATIONS

### A. Basic Requirements

1. Date Processed. The white turkey roasts (commodity) must not be processed and packaged more than 30 calendar days prior to the date of the contract.

2. Class and Style. The commodity must be prepared from young turkeys that conform to the definition for the class in 9 C.F.R. § 381.170 or in AMS § 70.202. Individual carcasses of turkeys must conform to definitions and standards found in 9 C.F.R. § 381.170 or AMS § 70.210.

3. Origin of Turkeys. Ready-to-cook white turkey roasts must be produced and processed from young turkeys which were produced, raised, and processed in the United States, its territories or possessions, the Commonwealth of Puerto Rico, or the Trust Territories of the Pacific Islands. If the contractor processes or handles turkey products originating from sources other than the United States, its territories or possessions, Puerto Rico, or the Trust Territories of the Pacific Islands, the contractor must have an acceptable identification and segregation plan for those turkey products to ensure they are not used in the commodities produced under this Specification. This plan must be made available to a representative of the Grading Branch, Poultry Division, AMS, USDA (grader), and the Contracting Officer or agent thereof upon request. The contractor must maintain records such as invoices, or production and inventory records evidencing product origin, and make such records available for review by the Government in accordance with Article 76 of USDA-1.

## **II.A.**

4. Inspection. Processing operations must comply with Poultry Products Inspection Regulations (9 C.F.R. Part 381) and be under the supervision of a representative of USDA's Food Safety and Inspection Service (FSIS) (inspector). Inspection for contract and Specification compliance will be in accordance with the Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products (7 C.F.R. Part 70) and the U.S. Classes, Standards, and Grades for Poultry (AMS 70.200 *et seq.*) under the supervision of a USDA grader. The USDA grader will be responsible for certification of compliance with the requirements of this Specification for ready-to-cook turkey products: preparation, formulation, and fabrication of white turkey roasts; packaging and packing; freezing; labeling and marking; sampling; net weight; and checkloading.

5. Product Temperature. Temperature of the products, unless otherwise specified, must comply with 9 C.F.R. § 381.66 throughout all operations including transportation between plants.

6. USDA Sampling Option. USDA may select additional product for further inspection or may draw samples for laboratory analyses.

7. Organoleptic Requirements. The chilled or frozen young turkey and turkey products will be examined on a continuous basis for the following organoleptic requirements: Chilled young turkey and turkey products must be free of rancidity; free of fruity, sulfide-like, cardboardy, tallowy, oily, oxidized, metallic, chlorine, or other foreign or off-odors; free of foreign materials (e.g., glass, paper, rubber, metal); must show no evidence of mishandling or deterioration; and must have a bright color with no evidence of dehydration or freezing and thawing. Any turkey or turkey product that does not comply with the organoleptic requirements will be rejected for use under this Specification.

8. Definition of a Lot. A lot is the amount of packaged commodity produced during a processing shift.

### **B. Preparation of Roasts**

#### **1. Sources of Meat**

a. Breast meat (meat) must be from nonbasted (no solution or ingredients added), young turkeys and turkey parts. The chilled deboned turkey breasts and meat must be used in the turkey roast within 7 calendar days after the day the turkeys are slaughtered.

b. Chilled boneless breasts and meat from frozen turkeys may be used when (1) the frozen turkeys have been packaged to protect them from freezer burn and dehydration during storage, (2) the turkeys have not been held more than 180 days in frozen storage and have been identified so the class of turkey can be determined, and (3) the resultant boneless meat is processed into the roasts (without refreezing) within 48 hours from the time of deboning.

### **II.B.1.**

c. Frozen boneless breasts and meat may be used when (1) produced from freshly slaughtered turkeys, (2) packaged to protect against quality deterioration during storage and identified so the time in storage and the class, kind, and specific deboned turkey product can be determined, and (3) held not more than 60 days in frozen storage. After thawing, the boneless breasts and meat must be used in the production of turkey roasts within 24 hours.

2. Turkey Products From Other Plants. Chilled and/or frozen turkey and turkey products may be transferred or obtained from other processing plants to produce roasts, provided they (a) have been processed, handled, and identified in accordance with this Specification, and (b) comply with the organoleptic, nonbasted, and other applicable requirements for turkey products to be used in roasts as evidenced by a USDA certification.

a. Type, class, and specific name of the product, part, boneless part or meat; date slaughtered, or date placed in frozen storage, as applicable; and the USDA-assigned plant number must be shown on each shipping container.

b. The chilled and/or frozen turkey products must be maintained at an internal product temperature not higher than 40 °F (4.4 °C) when shipped from the origin plant and when received at the destination plant.

3. Requirements for Meat and Skin.

a. Meat.

(1) Meat must be derived from turkey breasts. Meat must be in recognizable portions; that is, whole, half, or quartered breasts, and whole or half tenderloins. Scapula portion may be used, provided it is attached to the breast meat portion.

(2) Fatty blubber and spongy fat must be removed from the breast meat in the crop cavity.

(3) Mechanically separated turkey (comminuted, ground, chopped, or desinewed) cannot be used.

b. Skin. No skin may be used within roasts or to cover roasts.

c. Containers of breasts or meat must not contain added water (for example, water from ice or slush ice and water).

4. Defect Requirements. Boneless breasts and meat will be sampled and examined for compliance with the defect requirements shown in Table 1.

#### **II.B.4**

a. A sample of 10 pieces of each meat component will be sampled and examined

for the defects shown in Table 1, prior to being used in the formula. The frequency of sampling and the number of defects allowed will be those outlined in the Poultry Division acceptable quality level (AQL) Sample Plan 3 found in the Poultry Graders Handbook. Separate examinations will be made for (1) bone and (2) other defects.

b. Regardless of the kind and number of defects (within Table 1) found, any sample with bone or bone-like material greater than 0.75 inch (1.91 cm) will be cause for the rejection of the product the sample represents.

c. If the number of bone defects exceeds an "accept" level for the respective sample number, or results in a rejection, the frequency of sampling for bone defects will be increased to 10 pieces of the meat drawn twice each sampling interval until the cumulative number of bone defects reverts back to an "accept" level.

d. If the samples of meat have more defects than the maximum tolerance for the AQL sample plan, the product the sample represents will be rejected.

**Table 1. Defect Requirements for Meat**

<b>Breast Meat Defects:</b>	<b>Breast</b> with less than one-fourth of the meat.
<b>Tenderloin Meat Defects:</b>	<b>Tenderloin</b> with less than one-half of the meat.
<b>Meat Defects:</b>	
<b>Bone:</b>	<p><b>Bone or bone-like material</b> greater than 0.75 inch (1.91 cm) (<i>see II.B.4.b</i>).</p> <p><b>Bone or bone-like material</b> less than or equal to 0.75 inch (1.91 cm).</p>
<b>Other Meat Defects:</b>	<b>Cartilage</b> , bruise, blood clot, fatty blubber and spongy fat from the crop cavity or areas of discolorations as described below.
	<p><b>Any moderate discolorations.</b></p> <p><b>Lightly shaded discolorations</b> exceeding an area equivalent to the area of a circle having a diameter of 0.50 inches (1.27 cm). Slight discolorations are permitted, regardless of the area, provided the discoloration does not detract from the overall appearance of the meat.</p> <p><b>Skin</b> exceeding an area equivalent to the area of a circle having a diameter of 1 inch (2.54 cm).</p>

**II.B.**

## 5. Formula.



a. Formula. Proportions of ingredients required in preparing white turkey roasts:

	<u>Percent of Total</u>
Breast meat (minimum)	93.5
Water (maximum)	5.0
Salt, noniodized (maximum)	1.0
Sodium phosphates (maximum)	<u>0.5</u>
	100.0

(1) Except as otherwise specified in II.B.5.a.(2), only the ingredients and the percentages of ingredients listed in the formulation above may be used. Formulated batches of all ingredients must equal 100 percent.

(2) The amount and kind of restricted phosphates must be limited to those contained in 9 C.F.R. § 381.147. The salt must be noniodized.

b. Formulated batches of ingredients which do not comply with II.B.5.a. will be rejected for use in the roasts.

c. USDA may select additional samples of packaged roasts to examine for compliance with formulation requirements prior to shipment or at destination.

6. Mixing.

a. Salt, sodium phosphates, and water must be incorporated into the meat by tumbling or massaging. Tumbling or massaging must be accomplished without deforming, shredding, mutilating, or breaking up the pieces of meat.

b. Sodium phosphates and salt must be mixed with the water and added as a solution to the meat during tumbling or massaging. Sodium phosphates must be thoroughly mixed with the water prior to the addition of the salt to the solution.

c. The maximum tolerance of moisture, salt, and sodium phosphates applies to the meat and to each packaged roast.

**II.B.**

7. Hand and Mechanical Forming or Stuffing. Roasts may be fabricated by hand or by mechanically forming or stuffing. The mechanical process must: (1) result in finished roasts with recognizable pieces of breast meat, pieces of intact whole breast muscles, and intact pieces of

breast muscles; and (2) be approved in writing by the Director of the Poultry Division. (Approval will be granted on an individual plant basis after a review of the process and when the resulting fabrication is found acceptable by supervisory personnel of the Grading Branch, Poultry Division, AMS.)

8. Netting.

- a. After assembling, the formed roast must be enclosed in an elasticized netting.
- b. Roasts must be fabricated, netted, packaged, and packed so they will retain their unfrozen and netted shape after cooking, and each slice can be served with minimal separation.

9. Ready-to-Cook Roasts for Further Processing. Roasts may be delivered within the plant (see section VI.D.) when there is an approved contract for further processing between the processing plant and the final recipient of the product. Roasts delivered in this manner must be netted and delivered on a lot or subplot basis in the chilled state (at an internal product temperature not lower than 26 °F (-3.3 °C) and not higher than 40 °F (4.4 °C)), without being packaged in casings or plastic-film bags, for further processing under contract between the plant and the final recipient. Delivery (point of delivery and acceptance) within the plant must be under procedures approved by the Poultry Division.

C. Packaging and Packing

1. Material Requirements. All packaging and packing materials must comply with the requirements of this Specification, be clean and in new condition, and must not impart objectionable odors or flavors to the commodity.

a. Plastic-film bags, netting, and casings. Packaging materials--plastic-film bags, elasticized netting, or casings--must be safe (cannot adulterate product or be injurious to health) for use in contact with food products. The safety of food contact packaging materials will be determined by FSIS according to the criteria and procedures in 9 C.F.R. § 381.144.

b. Shipping containers.

(1) Requirements. Shipping containers for roasts must (a) be a fiberboard container; (b) be of such size to pack the product without slack filling or bulging; (c) protect the product against loss and damage; (d) withstand the variations in humidity and temperature during the conditions of use; and (e) have the combined facings weight, the bursting strength,

**II.C.1.**

and the compression strength (edge crush value) to withstand the stresses of handling, shipping, stacking, and storage.

(2) Container bottom. Flaps on the bottom of a shipping container must be securely fastened so the bottom remains securely fastened when the top of the container is

opened.

(3) Final closure. Final closure of the shipping containers for roasts must be secure and made with commercially acceptable filament-reinforced tape, plastic-film packaging tape, non-metallic strapping, adhesive, or other similar types of materials that are applicable for cold temperature storage conditions and that provide for safe handling of the commodity. Steel or wire straps must not be used for the final closure. Staples must not be used for the final closing of shipping containers. However, staples may be used to manufacture and to assemble the shipping containers, provided the staples are fastened into the container and tightly clenched to eliminate sharp edges prior to packing product into the shipping containers.

## 2. Packaging and Packing.

### a. Packaging.

(1) Requirements. After netting, a mechanically formed roast must be packaged in a casing and a hand-stuffed roast must be packaged in a plastic-film bag, casing, or heat-shrinkable plastic-film bag described in (2) below. Casings and bags must fit snugly around the roasts and be sealed by metal clip, plastic clip, or other device in a manner that will protect the product from dehydration, freezer burn, and quality deterioration. Metal wire ties, paper-coated wire ties, or staples must not be used for sealing plastic-film bags or casings.

(2) Casings and plastic-film bags. Casings for packaging turkey roasts must be made of plastic films with good moisture and oxygen barrier properties. Plastic-film bags must be a low-density polyethylene film bag with a wall thickness of not less than 2 mil (0.002 inch) or a heat-shrinkable, plastic-film bag with barrier properties and low-temperature stability characteristics equivalent to the 2 mil low-density polyethylene bag. Any seams in the casing or bag must provide the same protective qualities as the body of the casing or bag. Casings and plastic-film bags must have (a) low-temperature flexibility (not brittle) and durability to resist stress-cracking caused by the temperatures of freezing and frozen storage, and (b) the impact and tensile strength and tear resistance to protect the commodity from dehydration, freezer burn, quality deterioration or contamination during the conditions of use.

b. Packing. Four packaged roasts must be packed in each shipping container.

## II.

### D. Finished Product Requirements

1. Weight, Length, and Diameter Requirements. Unfrozen packaged roasts must comply with the following size requirements:

a. Weight. Each roast must weigh not less than 8 pounds (3.63 kg), and not more than 12 pounds (5.44 kg);

b. Length. Each roast must measure between 9 and 17 inches (22.9 to 43.2 cm) in length; and

c. Diameter. Each roast must measure between 4 and 7 inches (10.2 to 17.8 cm) in diameter.

2. Examination for Defects. Two packaged roasts will be sampled and examined for compliance with the size requirements (weight, length, and diameter), and exterior defects shown in Table 2.

a. The number of defects allowed will be as outlined in the Poultry Division AQL sample plan 4 found in the Poultry Graders Handbook.

b. If the sample has more defects than the maximum tolerance for the AQL sample plan, the product the sample represents will be rejected.

c. USDA may select additional samples of packaged roasts to examine for defects prior to shipment or at destination.

**Table 2. Defects for Finished Roasts**

<b>Size Defects:</b>	<b>A size defect for a finished roast is when the roast:</b>  Weighs less than 8 pounds (3.63 kg), or more than 12 pounds (5.44 kg);  Measures less than 9 inches (22.9 cm), or more than 17 inches (43.2 cm) in length; or  Measures less than 4 inches (10.2 cm), or more than 7 inches (17.8 cm) in diameter.
<b>Exterior Defects:</b>	<b>Flesh bruising</b> or any moderate discolorations on the meat.  <b>Lightly shaded discolorations</b> on the meat exceeding an area equivalent to the area of a circle having a diameter of 1.50 inches (3.81 cm).  <b>Skin</b> exceeding an area equivalent to the area of a circle having a diameter of 1 inch (2.54 cm).

**II.**

E. Metal Detection.

1. Requirements.

a. Each fabricated roast must be examined by a metal detection device (1) accepted by FSIS; and (2) capable of detecting metallic contaminants including, but not limited to, stainless steel shavings, metal clips, metal fragments from cutting equipment, and pieces of wire.

b. The roast must be presented correctly within the detection field pattern of the device. Procedures used must be appropriate for the dimensions, location, and pattern of the detection field, the "orientation effect" on the sensitivity of the device, the environmental conditions, and the commodity.

2. Operating Efficiency and Procedures. The operating efficiency of the metal detection device will be determined hourly by the USDA grader by placing a detection strip with a sphere of 440 stainless steel in the center of the detection field pattern. The Poultry Division will provide the detection test strip with the stainless steel sphere of the specified diameter.

a. Netted roasts must be examined prior to or after placing in the casing or plastic-film bag. As an alternate method, the meat used in the roast may be examined by an in-line metal detection device installed in the mechanical stuffing or forming system.

b. The USDA grader will use a detection test strip with a 3.00 mm (0.1181 inch) sphere for the examination of (1) packaged or netted roast, (2) packaged or netted roasts in a shipping container, or (3) the meat in an in-line system, as applicable, for the detection system.

c. As an alternate test method for an in-line detection device, a detection test strip with a 1.50 mm (0.0591 inch) sphere of 440 stainless steel may be placed in the detection field outside and adjacent to the device carrying meat.

3. Contaminated Product. These guidelines do not relieve the contractor of its responsibilities to provide a safe product. Product suspected of being contaminated with metal or found to be contaminated with metal will be handled in accordance with FSIS procedures.

4. Other Detection Procedures. Other procedures for examination of roasts or meat may be approved by the Director of the Poultry Division, in writing.

## II.

### F. Freezing

Packaged roasts must be placed in a freezer within 12 hours of fabrication and must be frozen by lowering the internal product temperature to 0 °F (-17.8 °C) or lower within 72 hours from the time of entering the freezer. If the packaged roasts are not placed in a freezer immediately after packaging, the roasts must be held at a room temperature not higher than 36 °F (2.2 °C) and not lower than 26 °F (-3.3 °C). When packaged roasts are held at a room temperature below 26 °F (-3.3 °C), the roasts will be considered to be in a freezer and subject to the 72-hour freezing requirement which begins at the end of the shift the roasts enter the 26 °F (-3.3 °C) or lower facility.

### III. LABELING

#### A. Packaged Roasts

1. Plant Number, Production Date, and Net Weight. The following information must be legibly preprinted, stamped, or stenciled on each casing or bag of roast; or preprinted, stamped, or stenciled on a waterproof tag in water-fast, nonsmearing ink and securely attached to the sealing device of each casing or bag of roast:

- a. The USDA-assigned plant number.
- b. Date of production (month, day, and year).
- c. The net weight must be shown, except for in-plant delivery where the roasts are delivered without packaging in casings or bags.

2. Name and Address. The name and address of the contractor/processor must not be shown on the packaging materials.

3. Additional Labeling Requirements. With the exception of the requirements in III.A.1. above, there must be no other labeling of the packaging materials.

#### B. Shipping Containers

1. Labeling Provisions. Labeling and marking of the product must be in accordance with this Specification. Labeling is subject to the provisions of 9 C.F.R. § 381.132(c). The name and address of the contractor/processor must not be shown on shipping containers.

2. Printing Requirements. Printed, stamped, and stenciled labeling and marking information on shipping containers and packaging materials must be water-fast, nonsmearing, of a contrasting color, clear, and readable.

### III.B.

3. Labeling Format. Any deviation from the labeling requirements in this Specification must be approved by the Contracting Officer, in writing, prior to start of production.

4. Recycle Symbol and Statement. The contractor shall place somewhere on the surface of each recyclable shipping container the recycle symbol shown in EXHIBIT 1. The statement "PLEASE RECYCLE" is to be placed under the symbol. The recycle symbol and statement must be legibly printed in permanent ink.

#### 5. Universal Product Bar Code.

a. A Universal Product Code (UPC), symbol and code, called Interleaved 2 of 5 (I 2/5), must appear on each shipping container. The complete code, including the check digit, must be printed in machine-readable and human-readable form. The start and stop

indicators will be included in the bar codes. Printing, readability, and scanability of the bar code must be in accordance with UPC guidelines published by Uniform Code Council, Inc., 8163 Old Yankee Road, Suite J, Dayton, Ohio 45458.

b. The contractor will use the code furnished by USDA. USDA has acquired a unique manufacturer's identification number for the commodity purchase programs and will use a unique item code number for the commodity purchased under this Specification. The contractors need not join Uniform Code Council, Inc.

c. The 14-digit UPC code for shipping containers of white turkey roasts is:  
1 07 15001 01539 3

d. The UPC code must be placed in the lower right-hand corner of both side panels of the shipping container.

6. Safe Handling Instructions. FSIS Safe Handling Instructions must be preprinted or applied as a separate pressure-sensitive label on each shipping container of commodity. The label must be in accordance with 9 C.F.R. § 381.125 and not cover the labeling information required within this Specification.

7. Labeling and Marking Information.

a. Requirements. Labeling and marking information must be preprinted, stamped, or stenciled on shipping containers. This information, in essentially the same layout, is provided in EXHIBIT 2, "Label Information for Shipping Containers of White Turkey Roasts."

b. "END" and "SIDE" designations. For the purpose of labeling and marking, the "end" and "side" panels may relate to the shortest and longest dimensions of the shipping container at the discretion of the contractor/processor. However, the panels must **III.B.7.**

alternate between "end" panel and "side" panel designation with the two side panels and two end panels being located on opposite panels of the shipping container.

8. TOP PANEL - Labeling and Marking. The following information must appear on the top panel of each shipping container:

a. Type, name, and ingredients statement. The ingredients statement must also be printed on the top panel of the shipping container following the commodity type and name. Ingredients must be listed by proper name and order in accordance with 9 C.F.R. § 381.118.

Frozen Ready-To-Cook  
WHITE TURKEY ROASTS  
Ingredients:

b. Storing instructions. The following storing instructions must be printed on the top panel of the shipping container:

PERISHABLE--KEEP FROZEN  
KEEP AT ZERO DEGREE F (-17.8 °C) OR BELOW

c. Key points for handling commodities. Handling information is required on each shipping container of commodity. The "KEY POINTS FOR HANDLING" must be legibly printed on the top panel of each shipping container. This information, in essentially the same layout, is set out in EXHIBIT 2.

d. Nutritional labeling. A nutritional label, indicating the nutrient content of the commodity, is required on the top panel of each shipping container of commodity. This nutritional facts information or "nutrition facts panel" must be in compliance with the FSIS nutritional labeling requirements found in 9 C.F.R. § 381.400(b) through § 381.499.

(1) The contractor/processor must select one of the following methods of providing the nutrition facts panel:

(a) Preprinted on the top panel of each shipping container; or

(b) Printed on a pressure-sensitive label and applied to the top panel of each shipping container. The pressure-sensitive label must not cover or conflict with the labeling requirements of this Specification.

(2) NOTE: The nutrition facts information and panel must be pre-approved by FSIS prior to shipment of the commodity. The method of providing and location of this information for each shipping container (preprinted or pressure-sensitive label) must be indicated on the FSIS label application. The pre-approved nutrition information must be **III.B.8.**

provided to the USDA inspection personnel at the plant where the commodity is to be packed for shipment.

9. ONE END Panel - Labeling and Marking. The following information must appear on one end of each shipping container.

a. Commodity name. The commodity name must be printed on the "one end" designated panel of each shipping container. The words "WHITE TURKEY ROASTS" must be printed in letters at least 1 inch (2.54 cm) high.

WHITE TURKEY ROASTS

b. Contract number, pack date, and net weight. The following information may be preprinted, stamped, or stenciled on the shipping containers, or on a separate pressure-sensitive label:

(1) Last five digits of the contract number as it appears in the acceptance wire.

(2) Date packed (month, day, and year).



(3) Net weight. The applicable net weight statement must be completed and printed on each shipping container:

4 Roasts Net Combined Weight \_\_\_\_ LBS.

c. Inspection mark and plant number. The USDA inspection mark and USDA-assigned plant number must be printed on the "one end" designated panel of each shipping container.

d. Storing instructions. The following storing instructions must be printed on the "one end" designated panel of each shipping container:

KEEP FROZEN

10. ONE SIDE Panel - Labeling and Marking. The following information must be printed **on the side panel immediately to the right of the "one end" panel** containing the information designated in III.B.9.:

a. Type, name, ingredients statement, and legend. The commodity type and name, ingredients statement, and the legend must be printed on the "one side" designate panel of each shipping container. Ingredients must be listed by proper name and order in accordance with 9 C.F.R. § 381.118.

### **III.B.10.**

#### **FROZEN READY-TO-COOK WHITE TURKEY ROASTS**

##### **Ingredients:**

Distributed by USDA in cooperation with State and local  
or tribal governments for domestic food assistance programs.

Not To Be Sold Or Exchanged.

b. USDA symbol. The USDA symbol, copy on back of Specification, is to be a minimum of 2.25 inches (5.72 cm) in height, and must be printed on the "one side" designated panel of each shipping container.

c. UPC code. The applicable UPC code (see III.B.5.) must be printed on the lower right-hand corner of the "one side" designate panel of each shipping container.

11. THE OTHER END Panel - Labeling and Marking. For each shipping container, the following information must appear on the end opposite the panel designated "one end:"

a. Name. The name of the commodity (see III.B.9.a.) must be printed on "the other end" designated panel of each shipping container.

b. USDA symbol. The USDA symbol (see III.B.10.b.) must be printed on the

end opposite the panel designated "one end."

12. THE OTHER SIDE Panel - Labeling and Marking. For each shipping container, the following information must appear on the side opposite the panel designated "one side:"

a. Type, name, and legend. The commodity type and name, and the legend (see III.B.10.a.) must be printed on the side opposite the panel designated "one side." **The ingredients statement is not required on this side of the shipping container for roasts.**

b. UPC code. The applicable UPC code (see III.B.5.) must be printed on the lower right-hand corner of "the other side" designated panel of each shipping container.

13. Inventory Control Label. The processor may use a pressure-sensitive label to place any additional information (including bar codes) for processor inventory control purposes. This label may be applied somewhere on the shipping container. The label must not (a) contain the contractor or processor name and address, or (b) cover or conflict with the labeling requirements of this Specification.

### III.

#### C. F.a.s. Vessel Deliveries

F.a.s. vessel deliveries that are not source loaded in a seavan are required to show the final destination's overseas address as provided in the Notice to Deliver. The address must be clearly printed on at least two sides of each pallet.

### IV. FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY

#### A. Material and Net Weight Compliance

##### 1. Verification of Materials and Defects.

a. Verification of packaging and packing materials. The contractor must verify compliance with packaging, packing, and marking material requirements by furnishing the USDA grader the following certification on company stationery signed by a person authorized to do so by the contractor:,

"(I)(We) certify that the packaging, packing, and marking materials used for any commodity presented for acceptance under this Commodity Specification for White Turkey Roasts dated August 1997, comply or will comply with the terms of this Commodity Specification.

Name \_\_\_\_\_

One certification is adequate for all production under this Specification.

b. Packaging defects. Packages in a delivery unit will be examined for defects that affect protection, expose product, or permit dehydration or freezer burn or quality deterioration during storage, such as tears, holes, or improperly sealed or closed packaging.

c. Packing defects. Shipping containers in a delivery unit will be examined for condition, labeling, and marking defects according to the United States Standards for Condition of Food Containers.

d. Tolerance for defects. If samples of packaged commodity or shipping containers in a delivery unit have more defects than the maximum tolerance for the applicable Poultry Division AQL sample plan, the delivery unit will be rejected.

#### IV.A.

2. Net Weight. Net weight of each delivery unit will be determined by the test-weighing procedures of the Poultry Division.

a. Test weighing procedures.

(1) The tare weight of all packing materials will be determined by weighing a representative sample of all packaging components such as plastic-film bags, clips, and fiberboard containers.

(2) A representative sample will be selected in accordance with the following sample plan:

<u>Number of Shipping Containers in Lot</u>	<u>Number of Shipping Containers in a Sample</u>
1 - 3	All
4 - 50	4
51 - 100	5
101 - 200	6
201 - 400	7
401 - 600	8

For each additional 100 cases, or fraction thereof, in excess of 600 cases, one additional case shall be included in the sample.

b. Purchase or delivery unit. A purchase or delivery unit must total 40,000 pounds (18,144 kg) net. A weight variation of plus or minus 1 percent is permitted on each delivery unit. USDA will pay the contractor for the amount of commodity delivered within the required weight range.

c. Net weight determination. Net weight will be determined at origin.

d. Alternate net weight verification. As an alternative to test weighing at time of checkloading, the contractor may request on-line verification of net weights for the commodity. Upon receiving the request, a Federal-State supervisor, Grading Branch, Poultry Division will determine that the facilities and procedures are in accordance with the applicable Poultry Division instructions for this Specification.

#### B. Prerequisites for Loading and Shipping Frozen Commodities

1. Visual Inspection. Frozen commodity must be a uniform light and bright color. Moisture (ice) present in a packaged roast must not exceed occasional small areas showing a thin layer of clear or pinkish-colored ice. Frozen commodity showing evidence of

#### IV.A.2.

weepage beyond the tolerance; or defrosting, refreezing, or freezer deterioration will be rejected for use under this Specification.

#### 2. Internal Product Temperature.

a. Requirements. Internal product temperature of the commodity must be 2 °F (-16.7 °C) or lower at time of loading. Delivery units with internal product temperatures exceeding 2 °F (-16.7 °C) and up to 5 °F (-15 °C) will be tentatively rejected. Tentatively rejected delivery units may be returned to the freezer and the temperature reduced to 2 °F (-16.7 °C) or lower and reoffered one time only. Delivery units exceeding 5 °F (-15 °C) or delivery units that have been tentatively rejected and exceed 2 °F (-16.7 °C) when reoffered, will be rejected for use under this Specification.

b. Optional temperature verification. As an option to verifying internal product temperature of frozen commodities at time of loading, the contractor may request an alternate method utilizing product temperature sensing devices. If this option is selected, a Federal-State supervisor will determine that the facilities, equipment, procedures, and the contractors' current level of freezing compliance are in accordance with the established guidelines outlined in the applicable Poultry Division instructions for this Specification.

#### C. Inspection and Checkloading

1. Requirements. Inspection for contract compliance will be made by a USDA representative, in accordance with 7 C.F.R. Part 70, 9 C.F.R. Part 381, and this Specification, at the site of processing, both during and after processing and packaging. A USDA representative may select samples for laboratory analyses or inspect the commodity at any point in transit and

after delivery to point of destination. Inspection records must be complete and made available to USDA, as requested, to assure contract compliance.

2. Procedures. The inspection and checkloading required by Articles 54 and 55 of USDA-1 must be performed by a USDA grader. Procedures to be followed and a schedule of fees for these services may be obtained by contacting the nearest Grading Branch field office or the Chief of the Grading Branch, Poultry Division, AMS, USDA, Room 3938-S, STOP 0258, 1400 Independence Avenue, SW, Washington, D.C. 20250-0258, telephone (202) 720-3271. The quality, quantity, weight, packaging, packing, and checkloading of the commodity must be evidenced by certificates issued by the USDA grader. The contractor must not ship the commodity unless informed by the USDA grader that the designated commodity to be shipped meets contract specifications.

## V. UNITIZATION

Each delivery unit of commodity must be unitized (palletized and stretchwrapped) and must comply with the following:

### V.

#### A. Pallets

Pallets must be good quality, wood, 48 inches x 40 inches, nonreversible, flush stringer, and partial fourway entry. Each pallet of shipping containers must be stretchwrapped with plastic film in a manner that will secure each container and layer of containers on the pallet. Palletized product must be loaded in a way that will prevent shifting and damage to the containers of product.

#### B. Pallet Exchange

Contractors may arrange for pallet exchange with consignees; however, USDA is in no way responsible for such arrangements.

## VI. SHIPMENT AND DELIVERY

Shipment and delivery must be made in accordance with this Specification, the applicable Announcement and Invitation, and Articles 56, 57, and 64 of USDA-1, as amended by the Announcement. In addition, the contractor must adhere to the following provisions:

#### A. Contract Compliance Stamp

Each shipping container must be identified with a USDA Contract Compliance stamp with the applicable certificate number. A USDA grader, or other authorized personnel under the supervision of the USDA grader, will stamp one end of each shipping container prior to shipment. If there is inadequate space available on either end of the shipping container, the stamp may be applied to a side of the container.

## B. Grading Certificate

A copy of the original USDA Poultry Grading Certificate issued at time of checkloading must accompany each shipment.

1. Railcar or Piggyback. If shipment is by rail or piggyback, the certificate must be placed in the railcar or trailer for easy access to the USDA grader, warehouseman, or consignee, as applicable.

2. Trucks. If shipment is by truck, the driver must, upon delivery, give the certificate to the USDA grader, warehouseman, or consignee, as applicable.

## C. Loading and Sealing of Vehicles

Loading must be in accordance with good commercial practices and the sealing must be done at origin under the supervision of a USDA grader.

## VI.C.

1. Railcar. Each railcar must be sealed. The contractors are responsible for arranging for railcar deliveries of more than one delivery unit so that each delivery unit contained in the same railcar can be completely separated and sealed.

2. Truck or Piggyback. Truck or piggyback shipments must be sealed at origin. A delivery unit shipped by truck or piggyback which includes split deliveries to two destinations will not require separation by sealing each drop.

## D. Delivery Notification

Notwithstanding the provisions of Article 56(c) of USDA-1, as amended by the applicable Announcement, the contractor must follow the instructions in the Notice to Deliver issued by the Kansas City Commodity Office (KCCO) concerning delivery notification. Such notification and information of impending delivery are vital in proper execution of delivery. The contractor must notify the State distributing agency and the consignee of shipment per instructions in the Notice to Deliver. For rail or piggyback shipments, notification shall be made on the day of shipment. For truck shipments, notification of the estimated arrival time should be made as far in advance of delivery as possible. In addition, for truck or piggyback shipments, the contractor must request and keep scheduled appointment(s). Unloading appointments for truck or piggyback shipments must be requested from the consignee contact party(ies) at least 24 hours in advance of delivery.

1. In-Plant Deliveries. When an in-plant delivery is made, the contractor must notify the appropriate resident USDA grader and furnish applicable information.

a. Definition of a subplot. A lot (the amount of commodity produced during a processing shift) may be separated into sublots. If this option is used, the commodity must be

sublotted on the basis of consecutively produced shipping containers or pallets. The sublots must be consecutively identified at the time of packing.

b. Roasts. Roasts may be delivered in the same plant where the roasts were produced in unfrozen form without casings or bags or without being packaged in containers (see II.E.15.). Such deliveries will be discounted, against the contractor's account, by 3.5 cents per pound.

2. Delivery In Storage. Delivery may be made in store provided the destination in the Notice to Deliver and the place the contractor has the commodity in storage are the same. Inspection and certification by a USDA grader are also required for transfers in store.

3. Early Delivery. The contractor may deliver early upon approval of the KCCO. Approval may be obtained by telephoning (816) 926-6068. Approval is contingent on the recipient's concurrence to accept early delivery and upon the USDA grader being available to perform necessary checkloading and final acceptance duties.

## **VI.**

### **E. Split Deliveries**

The contractor is responsible to deliver the quantity stated on each Notice to Deliver to each destination. Contractors must provide to the USDA Grader, at time of shipment, the number of boxes and pounds for each destination.

At the option of the contractor, a purchase unit with two Notices to Deliver (split deliveries) for two different destinations may be delivered on two separate trucks provided each truck ships the total quantity stated on the Notice to Deliver. Any additional costs will accrue to the contractor's account.

## **VII. DESTINATION EXAMINATION**

### **A. Commodity Requirements**

Before acceptance by consignee, frozen commodity may be examined by a USDA grader on a spot-check basis for temperature, condition, identity, and, when applicable, count. The commodity may be examined for conformance to contract provisions at any time required by the Contracting Officer.

### **B. Temperature**

Frozen commodity must arrive at destination at an average internal product temperature not to exceed 10 °F (-12.2 °C), with no individual temperature exceeding 15 °F (-9.4 °C). Commodity not meeting these requirements will be rejected for use under this Specification.

### **C. Cost for Frozen Commodity Destination Examination**

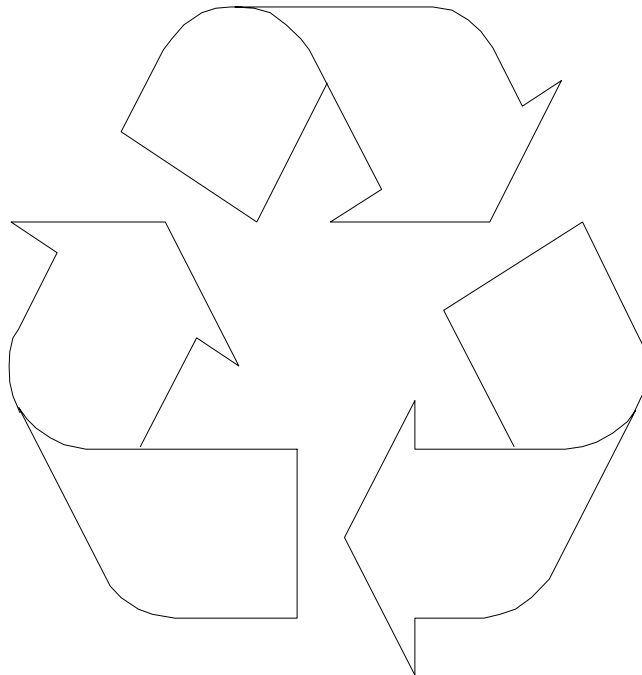
The cost of a destination examination for frozen commodity, before or after delivery by a USDA grader on acceptable product, will be for the account of USDA. Costs for destination examinations of rejected delivery units will be for the account of the contractor. The USDA origin grader will make arrangements for destination examinations prior to delivery.

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D. Michael Holbrook  
Director

Attachment

**EXHIBIT 1**  
**"Please Recycle" Symbol and Statement**








**PLEASE  
RECYCLE**

## EXHIBIT 2

### Label Information for Shipping Containers of White Turkey Roasts

**Marking Information:** Shipping containers shall be marked substantially as shown below. Markings must be preprinted, stamped, or stenciled on containers, water-fast, nonsmearing, of a contrasting color, clear, and readable. The words "WHITE TURKEY ROASTS," on each end, must be in letters at least 1 inch (2.54 cm) high. The USDA symbol is to be a minimum of 2.25 inches (5.72 cm) in height. The UPC 14-digit I 2/5 bar code (1 07 15001 01539 3) must be shown in the lower right-hand corner of both side panels. The recycle symbol and statement must be legibly printed somewhere on the surface of each recyclable shipping container.

<b>WHITE TURKEY ROASTS</b>			
<b>FROZEN READY-TO-COOK WHITE TURKEY ROASTS</b> Distributed by USDA in cooperation with State and local or tribal governments for domestic food assistance programs. Not To Be Sold Or Exchanged. UPC Code	<b>KEY POINTS FOR HANDLING WHITE TURKEY ROASTS</b>  <b>Handle Properly To Avoid Spoilage Or Possible Food Poisoning.</b>  <b>SORTING:</b> Roasts weigh 8-12 pounds (3.63-5.44 kg) each and are marked with their own weight. Roasts are 4-7 inches (10.16-17.78 cm) in diameter. Sort roasts by weight and diameter to facilitate thawing and/or cooking.  <b>THAWING:</b> Leave roasts in original casings and place in single layer on sheet pans or trays. Thaw refrigerated at 36°F-45°F (2.2°C-7.2°C). Space pans on refrigerated shelves so air can circulate. Do not hold thawed roasts longer than 24 hours before cooking.  <b>Thaw Only Amount Needed For 1 Day's Use. Avoid Leftovers. Do Not Thaw At Room Temperature Or In Water. Do Not Refreeze.</b>  <b>COOKING:</b> Remove from casings. Put roasts, thawed or frozen, in uncovered pan. COOK ROASTS TO AN INTERNAL TEMPERATURE OF 160°F (71.1 °C). Estimated cooking times at 325°F (162.8°C) are:  Deck Oven      4 - 5¼ hours Convection Oven   3 - 4 hours  <b>The Diameter Can Affect The Cooking Time More Than The Weight. The Greater The Diameter, The Longer The Cooking Time.</b>	<b>Frozen Ready-To-Cook WHITE TURKEY ROASTS</b>  <b>Ingredients:</b>  <b>SERVING:</b> It may be easier to remove the netting and slice cooked roasts after they have cooled. If using a slicer, chill roasts thoroughly first. Serve as an entree, in sandwiches or salads, or in any recipe specifying cooked turkey. Refrigerate any leftovers and use within 2 days. For recipes, see PA-1371, "Quantity Recipes for School Food Service" and "A Tool Kit for Healthy School Meals: Recipes and Training Materials."  <b>YIELD:</b> One pound of white turkey roast provides 10.5 1-ounce (28.35-g) servings of cooked lean meat.  Nutrition Facts Panel May Be Placed Here.  Safe Handling Instructions May Be Placed Here.  <b>PERISHABLE--KEEP FROZEN</b> <b>KEEP AT ZERO DEGREE F (-17.8 °C)</b>  <b>OR BELOW</b>	<b>FROZEN READY-TO-COOK WHITE TURKEY ROASTS</b> <b>Ingredients:</b> Distributed by USDA in cooperation with State and local or tribal governments for domestic food assistance programs. Not To Be Sold Or Exchanged. UPC Code  
<b>WHITE TURKEY ROASTS</b>  <b>KEEP FROZEN</b>			
4 Roasts Net Combined Weight ____ LBS.		CONTRACT NO. _____ DATE PACKED Month, Day, and Year	